

Work Order ID 68899

Page 1

Monday, April 25, 2011 10:50:06 AM

Item ID: D2562-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 4/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2562	Rev D

100 0.00



NC BRAKE

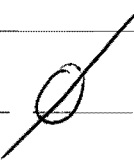
Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2562

8x  m-f 11/05/25

110 0.00



Small Fab

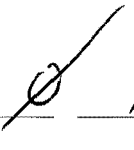
Small Fab

Memo

0.00

Small Fab

1- Bend end as per Dwg D2562 Angle "D" □ 2-Debur

8x  m-f 11/05/25

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

5/10/30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68899



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Monday, April 25, 2011 10:50:06 AM

Item ID: D2562-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 4/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:20

0.00

3:50

8X ϕ m.p 11/05/31

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 ϕ BR 11-5-31

150



Packaging

Packaging

Identify as per dwg & Stock Location

264

0.00

Memo

0.00

11/6/11 SP (82)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 68899

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Monday, April 25, 2011 10:50:06 AM

Item ID:	D2562-001	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut					
Start Date:	4/25/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	4/29/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/2011
mf
11-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 25, 2011 10:50:12 AM

Page 1

Work Order ID: 68899



Parent Item: D2562-001



Parent Item Name: Strut

Start Date: 4/25/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP ☐ F ☐ 02.04.15 ☐ Added dwg Rev.B1 ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

11.7907

1.7067

14.37221



mk 11/05/25

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

11.79068

115535

2.33

115990

5.29

116720

4.17068

M117598

14-37221

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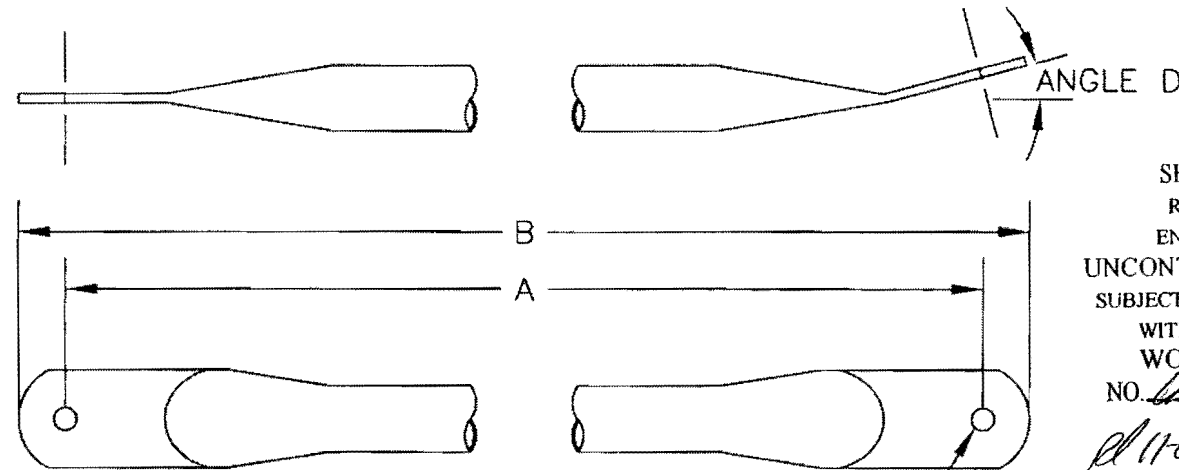
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44899

11-04-25

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2562
DATE	TITLE	REV. D
05.05.18	STRUT	SHEET 1 OF 1
		SCALE
		1:2
A	96.05.01	NEW ISSUE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)
C	02.06.05	ADD -005; ADD FINISH
D	05.05.18	ADD -007/-011/-013; UPDATE -005



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

20.705

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05-05-27

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